

Work Order ID 60976

August 3, 2010 1:33:27 PM

Page 1

PRELIMINARY ISSUE

Item ID: D4155-1

Accept

Revision ID: PRELIM

Item Name: Bar

Start Date: 8/03/10 Start Qty: 2.00

Required Date: 8/05/10 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4155

PA1

100

0.00

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg

Dwg Rev: PA1

Prog Rev: PA1

2-Deburr if necessary

0.00

FB 10-8-4

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Quality Control

Memo

0.00

FB 10-8-4

[illegible]

August 3, 2010 1:33:27 PM

1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100	101	102	103	104	105	106	107	108	109	110	111	112	113	114	115	116	117	118	119	120	121	122	123	124	125	126	127	128	129	130	131	132	133	134	135	136	137	138	139	140	141	142	143	144	145	146	147	148	149	150	151	152	153	154	155	156	157	158	159	160	161	162	163	164	165	166	167	168	169	170	171	172	173	174	175	176	177	178	179	180	181	182	183	184	185	186	187	188	189	190	191	192	193	194	195	196	197	198	199	200	201	202	203	204	205	206	207	208	209	210	211	212	213	214	215	216	217	218	219	220	221	222	223	224	225	226	227	228	229	230	231	232	233	234	235	236	237	238	239	240	241	242	243	244	245	246	247	248	249	250	251	252	253	254	255	256	257	258	259	260	261	262	263	264	265	266	267	268	269	270	271	272	273	274	275	276	277	278	279	280	281	282	283	284	285	286	287	288	289	290	291	292	293	294	295	296	297	298	299	300	301	302	303	304	305	306	307	308	309	310	311	312	313	314	315	316	317	318	319	320	321	322	323	324	325	326	327	328	329	330	331	332	333	334	335	336	337	338	339	340	341	342	343	344	345	346	347	348	349	350	351	352	353	354	355	356	357	358	359	360	361	362	363	364	365	366	367	368	369	370	371	372	373	374	375	376	377	378	379	380	381	382	383	384	385	386	387	388	389	390	391	392	393	394	395	396	397	398	399	400	401	402	403	404	405	406	407	408	409	410	411	412	413	414	415	416	417	418	419	420	421	422	423	424	425	426	427	428	429	430	431	432	433	434	435	436	437	438	439	440	441	442	443	444	445	446	447	448	449	450	451	452	453	454	455	456	457	458	459	460	461	462	463	464	465	466
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[REDACTED]

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[illegible]

Customer:

[illegible][illegible]

Date:

**Insp.
Stamp**

0.00 - Inspector to RA/Ding

[illegible]

0.00 δ volozlos κ

0.00

Weld per dwg A/R Hardcoat steel Batch: M1/4898 0.00



0.00

0.00

0.00

0.00

EL 10-8-9 12

11 10.08.09

Work Order ID 60976

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Page 3

Item ID: D4155-1

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Bar

Start Date: 8/03/10

Start Qty: 2.00



Cust Item ID:

Required Date: 8/05/10

Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

*inspect to PA 1
Dwg only*



QC

Memo

0.00

Quality Control

8/10/04/16

160

Identify as per dwg & Stock Location: *W/O*

0.00



Packaging

Memo

0.00

Packaging

60976

EL 10-8-9 x0

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/04

POSITIVE RECALL

EFFECTIVE *10-8-03* AUTH *W*

RELEASED *10-10-04* DATE *10.10.04*

PER ATTACHED ~~RECALL~~ ~~RECALL~~
DWG ~~2010-04-15~~
+ Release on 3

MF 10-10-04

Picklist Print

August 3, 2010 1:33:25 PM

Page 1

Work Order ID: 60976

Parent Item: D4155-1

Parent Item Name: Bar



Start Date: 8/03/10

Required Date: 8/05/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.08.03 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304B0.500X012.000

Purchased

No

100

sf

2.9410

1.27

2.673684



304 BAR .500 X 12.00



1210-8-4

304 BAR .500 X 3.125

Location

Loc Qty

Loc Code

MAT53

2.941

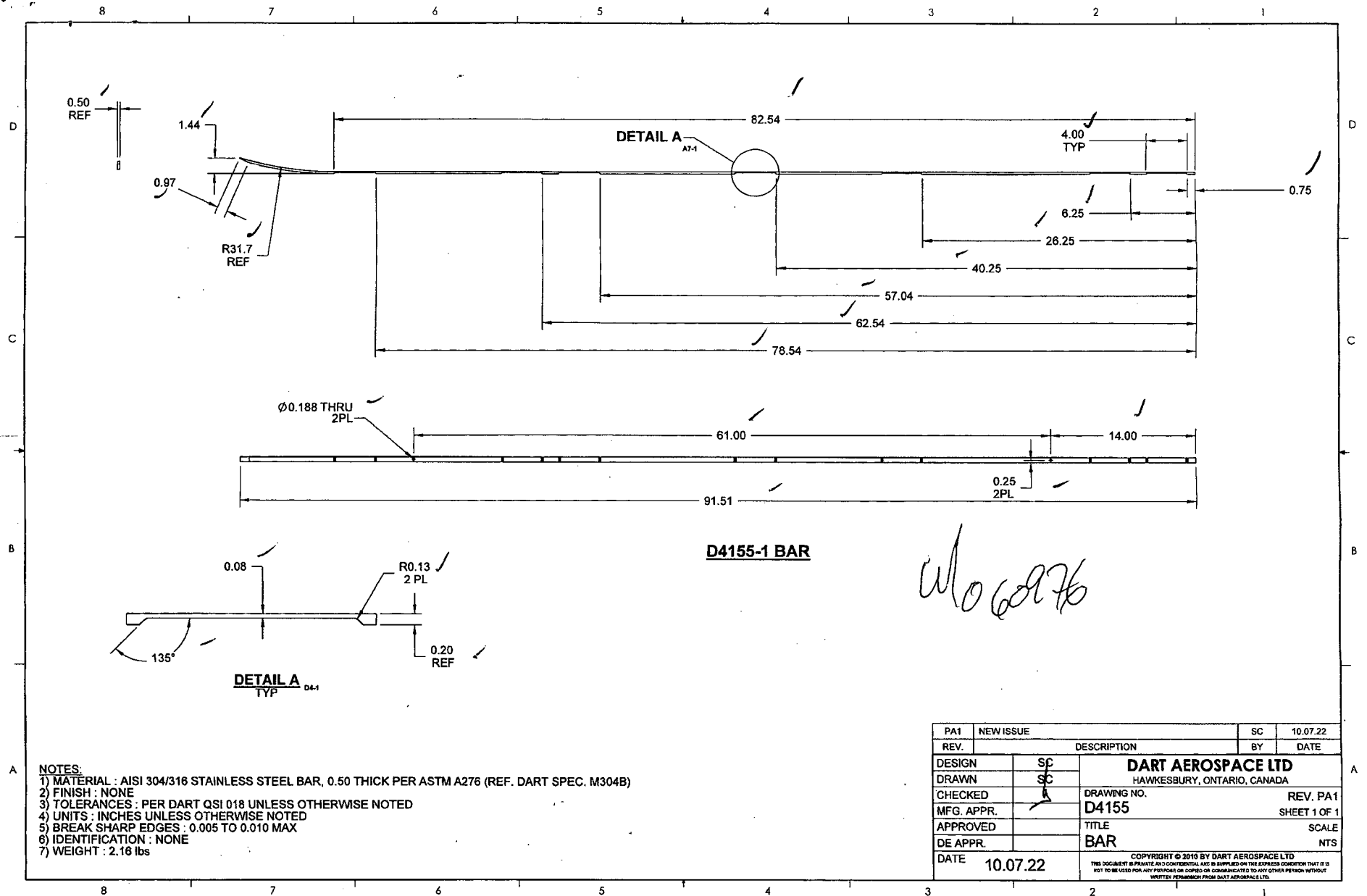
112778

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②



DART AEROSPACE LTD		Work Order: 60976
Description: WEAR BAR		Part Number: D4155-1
Inspection Dwg: D4155-1 Rev: PA1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

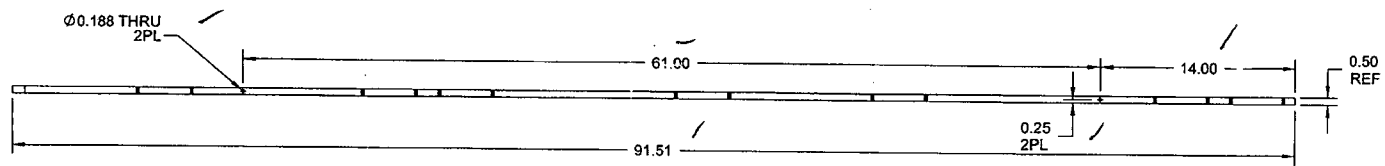
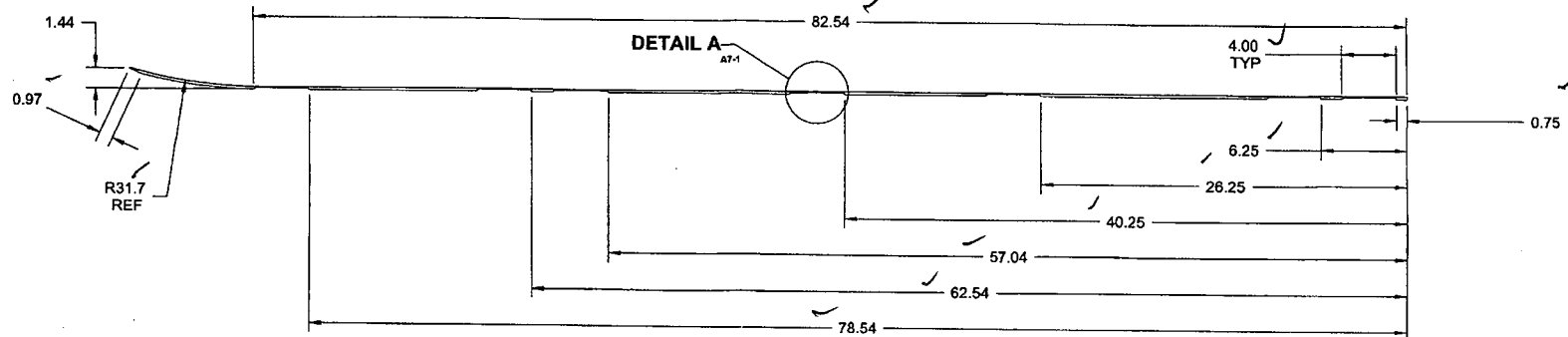
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.50	$\pm .03$.510	X		V IB 62	
.20	$\pm .030$.201	X		V	
.08	$\pm .030$.083	X		V	
91.51	$\pm .030$	91.51	X		T IB 01	
.75	$\pm .030$.760	X		V	
4.00	$\pm .030$	4.002	X		V	
6.25	$\pm .030$	6.260	X		V	
26.25	$\pm .030$	26.25	X		T	
40.25	$\pm .030$	40.25	X		T	
57.04	$\pm .030$	57.00	X		T	
62.54	$\pm .030$	62.54	X		T	
78.54	$\pm .030$	78.54	X		T	
82.54	$\pm .030$	82.54	X		T	
.97	$\pm .030$.960	X		V	
1.44	$\pm .030$	1.460	X		V	

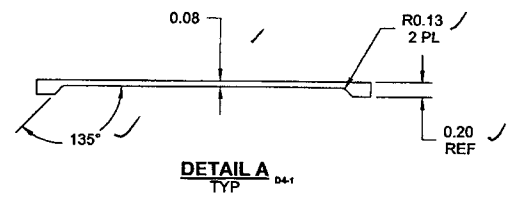
Measured by: IB	Audited by: S	Prototype Approval: N/A		
Date: 10-8-4	Date: 10/08/05	Date: N/A		
to PA1 Dwg only				
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

8 7 6 5 4 3 2 1

#60976



D4155-1 BAR



60976

RELEASED
2010-09-15

- NOTES:**
 1) MATERIAL : AISI 304/316 STAINLESS STEEL BAR, 0.50 THICK PER ASTM A276 (REF. DART SPEC. M304B)
 2) FINISH : NONE
 3) TOLERANCES : PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS : INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES : 0.005 TO 0.010 MAX
 6) IDENTIFICATION : NONE
 7) WEIGHT : 2.16 lbs

A	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	SC	DRAWING NO.	REV. A
MFG. APPR.	SC	D4155	SHEET 1 OF 1
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	BAR	NTS
DATE	10.07.22	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1